

Work Order ID 48358 - 2

June 26, 2009 11:13:23 AM

Item ID: D3414-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 15/07/2009 Start Qty: ~~16.00~~

Required Date: 03/08/2009 Req'd Qty: ~~16.00~~

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev B

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3414

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

0.00

0.00



110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00



QC2- Inspect parts off machine FAI/FAIB

split - 2

Work Order ID 48358

June 26, 2009 11:13:23 AM

Page 2

Item ID: D3414-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 15/07/2009 Start Qty: 16.00

Required Date: 03/08/2009 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Brake NC

Brake NC

0.00

Memo

0.00

1-Deburr

2-Form using DT8254 as per Dwg D3414

140

Large Fab

Large Fab

0.00

Memo

0.00

1- Weld using location Jig DT8484 as per Dwg D3414

EL

9-8-22

X5

Work Order ID 48358

June 26, 2009 11:13:23 AM



Page 3

Item ID: D3414-041
Revision ID: B
Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 16.00



Required Date: 03/08/2009 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

PPL 09-08-24 (5)

0.00

Memo

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) 509/08/24

0.00

Memo

(5)

φ

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

0.00

Memo

M112266

START TIME:

1:39pm

OVEN TEMPERATURE:

400°F

FINISH TIME:

2:00pm

m 09/08/24

(5)

φ

Work Order ID 48358

June 26, 2009 11:13:23 AM

Page 4

Item ID: D3414-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 15/07/2009 Start Qty: 16.00

Required Date: 03/08/2009 Req'd Qty: 16.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

DL 09-08-24 (5)

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 473

0.00

9/8/26 (5) SP

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

09/08/27 (5)

QC

Memo

0.00

Quality Control

DL 09-8-26 (5)

Picklist Print

June 26, 2009 11:13:23 AM

Page 1

Work Order ID: 48358



Parent Item: D3414-041RevB

Parent Item Name: Lug Assembly

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 16.00

Required Qty: 16.00

Comments: Rev:B rev.B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	0.0000	24.3200			
304/316 0.100" Sheet												
D3414-3RevB		Manufactured	No			160	Each	0.0000	16.0000			
Lug												



~~B50471~~ ~~15~~ ~~17-8-09~~

↓ D3414-1 B50309A

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 48358
Estimate Number : 10774
P.O. Number :
This Issue : 03/06/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 47709
Written By :
Checked & Approved By : JLD 09-06-03
Comment : Est A 05.09.13 New issue KJ/JLM
Est Rev:B 09-02-26 rev.b as per dwg DD verified by:EC

Drawing Name : LUG ASSEMBLY
Part Number : D3414041
Drawing Number : D3414 REV.B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 15/06/2009 Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S12GA

304/316 0.100" Sheet



Comment: Qty.: 0.1523 sf(s)/Unit Total : 2.4360 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: 105130 B9-6-19

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: B

Prog Rev: B

B9-6-19

(71)

2-Deburr if necessary

B9-6-19

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

counts

50206/19

(124)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414

B9-6-19 (24)

Date: Wednesday, 03/06/2009 10:48:57 AM
User: Julie Dawson

Process Sheet

Drawing Name: LUG ASSEMBLY

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 48358

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
Soldered (x24)

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Lug

Pick:

Qty

Part Number Description

Batch

1

D3414-3

Lug

B50471

A/R

SS Rod

M9676

EL 9-8-22

25

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

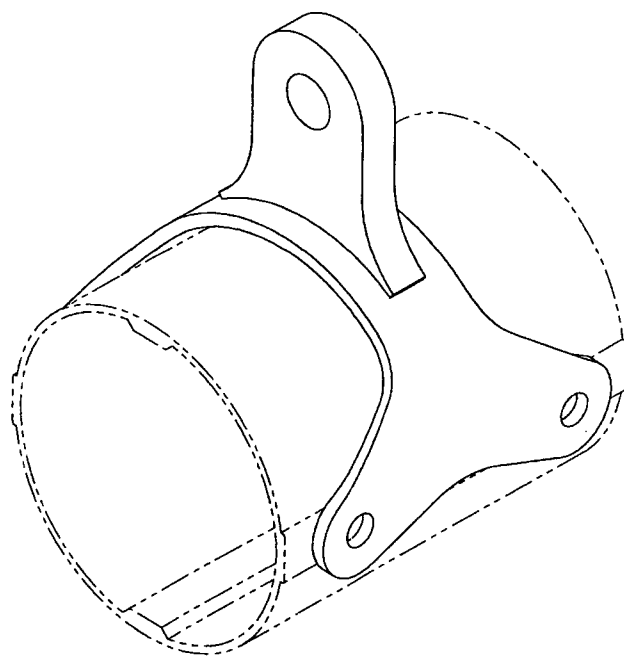


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

See ATTACHED w/o for completion

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
7	1	D3414-1	LUG BRACKET
8	1	D3414-3	LUG

△B



D3414-041 LUG ASSEMBLY

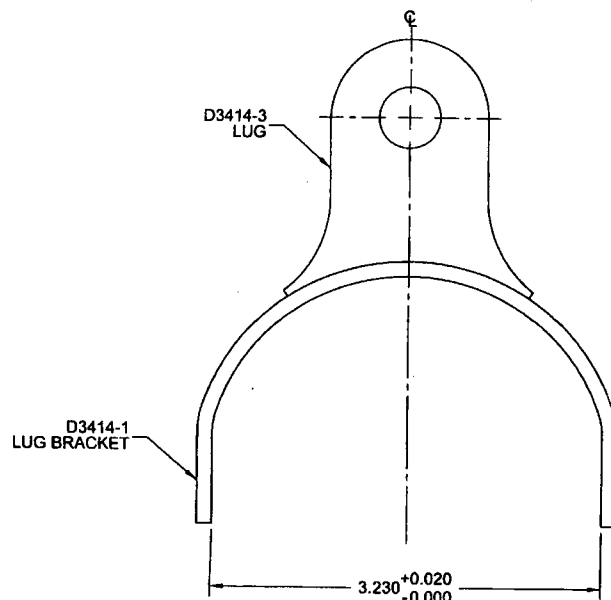
RELEASED
09/02/16

NO. 18358
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

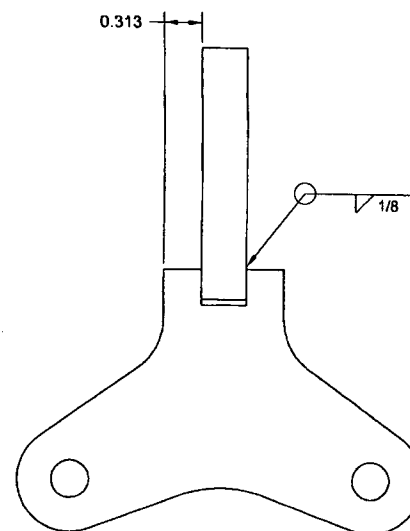
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART08). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. SHEET 3 ZONE B7 ADDED TOLERANCE TO 3.230 DIM.		AJS	08.09.23
A	NEW ISSUE		CP	05.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3414 TITLE LUG ASSEMBLY COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED		REV. B		
DE APPR.		SHEET 1 OF 3		
DATE	08.09.23	SCALE		
NTE				



D3414-041 LUG ASSEMBLY

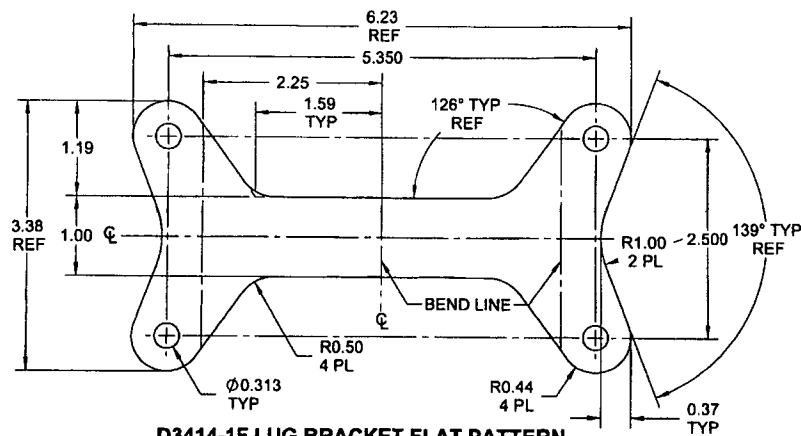


RELEASED
08/02/18 M

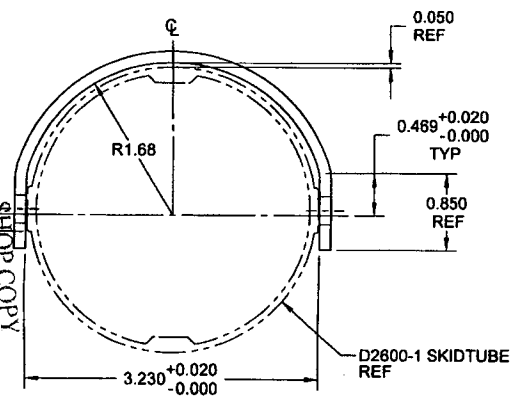
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 148358

DESIGN	CP
DRAWN	AJS
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.23

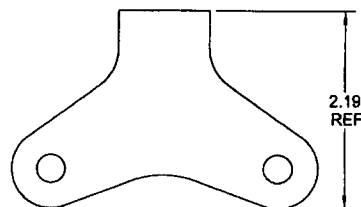
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. B
DRAWING NO. D3414
SHEET 2 OF 3
SCALE NTS
TITLE LUG ASSEMBLY
AEROSPACE LTD
COPYRIGHT © 2005 BY DART
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



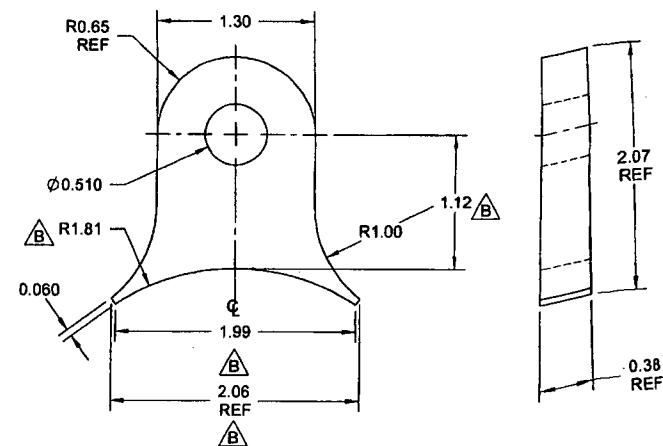
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

- NOTES:
- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

RELEASED
08/09/23

DESIGN	QP
DRAWN	AJS
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.23

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3414

TITLE

LUG ASSEMBLY

REV. B

SHEET 3 OF 3

SCALE

NTS

COPYRIGHT © 2003 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.